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(54) TURNING CONTROL METHOD

(57) Abstract:

PURPOSE: To correct the servo delay in synchronous feeding and thereby perform an efficient thread cutting, by changing the revolving speed of the spindle at the coarse and finish processing phases in the thread cutting process and by making correction of the cutter position at the time of starting accordingly.

CONSTITUTION: When thread is to be cut on a work WK, a higher processing efficiency will be obtained if the revolving speed of the work WK is different between the coarse and finish phases. Because the synchronous servo motion of the cutter in the Z direction has different servo delays dL and dS according to the feed speed fL, fS, a proceeding of the thread cutting without special consideration will yield a double thread and lower the accuracy. The positions of cutter's tip can be put identical between the coarse and finish phases by making correction of the cutter position at the time of starting (position in the direction of Z or Q axis) in accordance with the feed speed fL, fS. Thus thread cutting in high precision can be made at a high efficiency.